



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5489-045

Job Sheet 193266-A



Part No: D5489-045

Job Qty: 6 pcs

Part Name: Wearplate Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/19/19

Job Tracking No:

Due Date: 7/15/19

Created By: Eric Larocque

Type: SOLD

Description:

Note: D5489 REV.B IPP REV:A 17.11.03 AS PER DWG REV.A DD VERF:JFS REV:B 18.05.06 PRELIM B7 DD VERF:JFS IPP REV:C 18.08.15 AS PER DWG REV.B DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
140	QC 5	6 pcs	7/15/19	7/15/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
150	Automated Welding - B4B	6 pcs	7/15/19	7/15/19	0.00	2.00	Automated Welding - 1 - B4B		MC
160	QC 10	6 pcs	7/15/19	7/15/19	0.00	0.00	QC 10 - 10		Q
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		
							QC 10 - 9		
170	QC 5	6 pcs	7/15/19	7/15/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		



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Container No: S199134



Part: D5489-045

Job No: 193266-A

Serial No/Batch: S194692

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 07/22/19

					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	CE
					QC 5 - 30	
					QC 5 - 40	
180	Handfinish - 4-1-Assembly-B4B	6 pcs	7/15/19	0.00 2.00	Handfinish - 4 - 1 - B4B	
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	AB 19-7-23
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	
					Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	
					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	
					Handfinish - 4 - 9 - B4B	
190	QC 3	6 pcs	7/15/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	JUL 24 2019
					QC 3 - 19	DAS 40 9-89
200	Packaging 3-1 - Stock - B4B	6 pcs	7/15/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	

				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210	QC 21 - SA	6	7/15/19	0.00 0.00	QC 21 - SA - 21
		pcs			QC 21 - SA - 70
					QC 21 - SA - 53

548
21
9-88

JUL 29 2019

Part Op 140 - (QC5- Inspect part completeness to step on W/O)
 Descriptions: 150 - ***SEE NOTE 8,9 FOR SURFACE BUILDUP*** 1- WELD AS PER DWG AND QSI004 4.5 FOR AUTOMATED WELDING USE 8259 HARDCOAT BATCH: 4138901
 160 - (QC10- Inspect visual per QSI004- ground welds)
 170 - QC5- Inspect part completeness to step on W/O)
 180 - (Assemble as per dwg) COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG AND PER QSI005 A/R ROCKGUARD BATCH: 5192286
 190 - (QC3- Inspect Part Finish)
 200 - (Identify as per dwg & Stock Location: _____) LOCATION : FP002
 210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Job BOM records could not be found.

Job Allocations

Job Allocations could not be found.

Part Specifications

Specifications could not be found.

Plex 7/19/19 7:19 AM dart.larocque.eric

011111



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200
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C45-8-2

Job Sheet 193454



Part No: C45-8-2

Job Qty: 20 pcs

Part Name: Solenoid



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/15/19

Job Tracking No:

Due Date: 5/10/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: C45-8-2 REV.5 IPP REV:A 18.02.07 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	20 pcs	5/10/19	5/10/19	0.00	1.00	External Load - 1		AP 2019/07/29 Made/ 2019-7-26
							External Load - 2		
							External Load - 3		
							Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	20 pcs	5/10/19	5/10/19	0.00	0.00	QC 5 - 10		DAS 61 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	Packaging 3-2 - Stock - B4B	20 pcs	5/10/19	5/10/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		



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Container No: S201006



Part: C45-8-2

Job No: 193454

Serial No/Batch: S201006

Revision: 5

Inspector:

Exp Date:

Instructions:

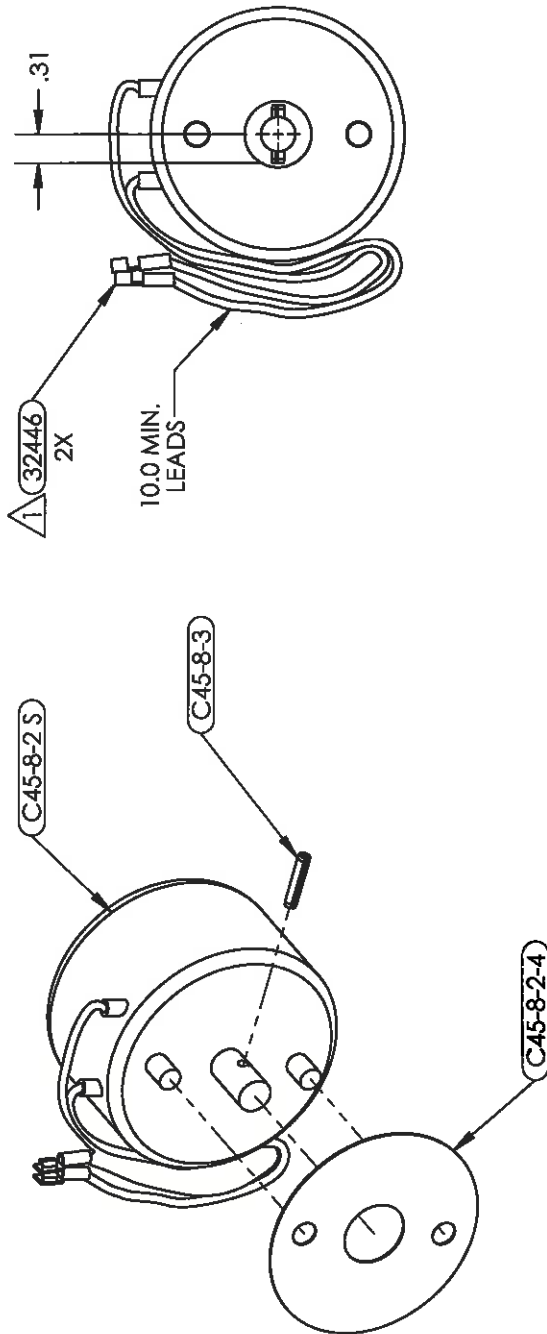
Date: 07/29/19

Plex 4/15/19 12:59 PM Dart.lajeunesse.marie

					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	PC 6 A206
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	D48
140 QC 21 - FG	20 pcs	5/10/19	0.00 0.00	QC 21 - FG - 21	21	AUG 02 2019
				QC 21 - FG - 70	95%	
				QC 21 - SA - 53		
Part Op 100 - (Small Fab)1-Assemble as per DWG sheet 1. 2-Center C45-8-3 in shaft of solenoid as per note 1. ***Note 32446 Descriptions: 22-16 crimp connectors supplied loose as per note 1*** 110 - (QC5- Inspect part completeness to step on W/O) 130 - (Identify as per dwg & Stock Location: _____) 140 - (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
32446	Crimp Terminal	40 Ea (2 ea)	100-Small Fab - 1	32 5047075		
C45-8-2-4	Spacer	20 pcs (1 ea)	100-Small Fab - 1	8 5176361		
C45-8-2S	Solenoid	20 pcs (1 ea)	100-Small Fab - 1	5199779		
C45-8-3	Split Pin 923BA179	20 pcs (1 ea)	100-Small Fab - 1	5029600		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-Small Fab - 1	32446	40	712	0		
	C45-8-2-4	20	24	0		
	C45-8-2S	20	0	0		
	C45-8-3	20	100	0		
Part Specifications						
Specifications could not be found.						

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
2		AS DRAWN BY CANAM.	7/29/2014	JAG
3		ADDED SPACER C45-8-2-4.	7/29/2014	RJC
4	14-0099	CHTD TITLEBLOCK WAS RED BARN IS DART. ADDED MCMASTER-CARR INFO FOR C45-8-3. CORRECTED BO INFO FOR C45-8-2-4 WAS Ø1.75 IS Ø2-5/8. ADDED DIM .31. ADDED CONNECTORS SUPPLIED LOOSE NOTE. CHTD P/N WAS C45-8-2 IS C45-8-2-3. C45-8-2-3 CHD DIMENSION FROM .340 TO 11/32. CHD TOLERANCE ON NON-CRITICAL DIMENSIONS.	7/29/2014	RW
5	15-0221	C45-8-2-5 REPLACED WITH 32446.	8/24/2015	DPD
				JAG



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WITHOUT NOTICE

WORK ORDER
NO. 193454 MWS
19-04-15

NOTE:
CONNECTORS SUPPLIED LOOSE.



TITLE
SOLENOID C45-HOOK

DWG NO. C45-8-2
REV 5

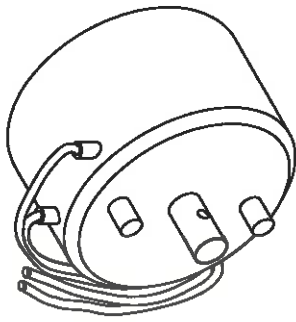
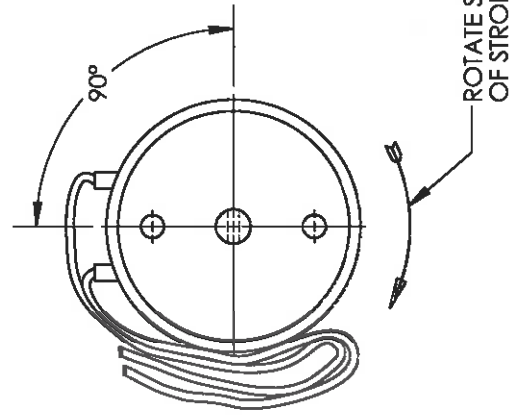
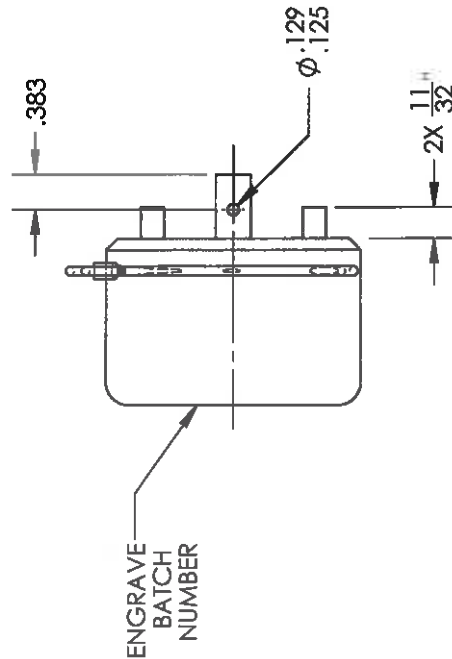
DRAWN BY:		APPROVED
UNLESS OTHERWISE SPECIFIED		REAT
DIMENSIONS ARE IN INCHES		FINISH
.XXX ± .005		ANGLES ± .5°
.XX ± .01		SPEC
.X ± .1		USED ON MODEL
1. BREAK ALL SHARP EDGES .015 x 45°		
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		
SCALE	1:2	DATE
		SHEET 1 OF 3

ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
		C45-8-2 S	1	SOLENOID		TESTCO H-2553-020 (MODIFIED)	2
		C45-8-2-4	1	SPACER	PETG	Ø2-5/8 X .020	3
	B/O	C45-8-3	1	SPLIT PIN	18-8 S.S.	Ø1/8 X 5/8 (MCMASTER-CARR #92373A179)	1
	B/O	32446	2	22-16 AWG KNIFE CONNECTOR		(ALLIED ELECTRONICS 32446)	1

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REVISIONS

REV	FCR	DESCRIPTION	DATE	INITIAL	APPROVED
4	14-0099	C45-8-2 S CHD DIMENSION FROM .340 TO 11/32.	7/29/2014	JAG	GE



SOLENOID C45-HOOK

TITLE	DWG NO.	REV
SOLENOID C45-HOOK	C45-8-2 S	5
DRAWN BY:	APPROVED	
CANAM	<i>D. Med.</i>	
UNLESS OTHERWISE SPECIFIED	TEST	
DIMENSIONS ARE IN INCHES	FRACTIONS ± 1/8	
DECIMALS ± .01	ANGLES ± .6°	
FINISH	SPEC	
1. BREAK ALL SHARP EDGES .015 x 45°	USED ON MODEL	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		
SCALE	DATE	SHEET 2 OF 3
1:2	5/15/1997	

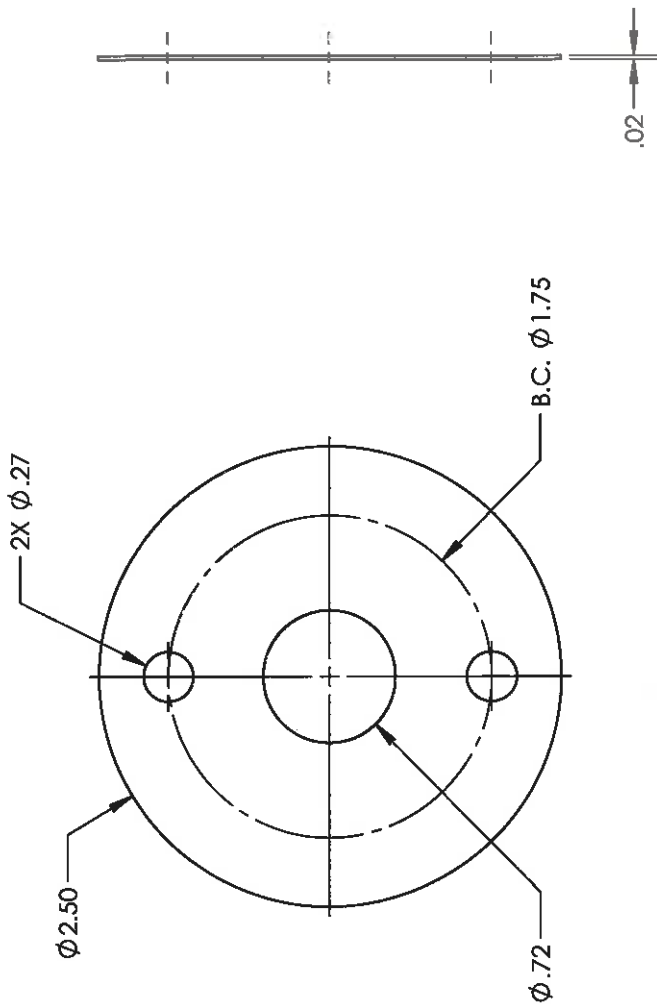
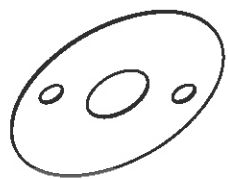
C45-8-2 S

SOLENOID

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REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3		ADDED SPACER C45-8-2-4.	10/10/2012	RJC	DW
4	14-0099	C45-8-2-4 CORRECTED BO INFO WAS Ø1.75 IS Ø2-5/8.	7/29/2014	JAG	RW



DART
AEROSPACE

SOLENOID

TITLE					
DWG NO.	C45-8-2-4				
REV	5				
MAT'L	PETG	DRAWN BY:	CLOUGH		
UNLESS OTHERWISE SPECIFIED		APPROVED	<i>D. Hall</i>		
DIMENSIONS ARE IN INCHES		TEST			
.XXX ± .005		FINISH			
.XX ± .01		ANGLES ± .5°			
.X ± .1		1. BREAK ALL SHARP EDGES .015 x 45°			
OR .018R		2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
USED ON MODEL		SCALE	1:1	DATE	10/30/2012
		SHEET 3 OF 3			

C45-8-2-4

SPACER

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		DEPARTMENT/PROCESS		MRB (QS1042)	
Date : _____		Sequence #: _____		QTY Affected : _____			
Description Work Order Deviation		Disposition					
Completed By		Lead hand / Supervisor					
QC / QA Coordinator		_____					

Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ _____ _____ _____ _____ _____ _____ _____		FAULT CATEGORY							
Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			